



SIDDHI TRADE ENTERPRISE

HSDR

CERTIFICATE OF ANALYSIS

Introduction:

HSDR is especially over designed blend of film forming material, corrosion inhibitor, extreme pressure additives, chlorine free anti wear additive and other products based on selected eco friendly additives to meet the demands of hobbing cutting, neat cutting, stamping and drawing, stainless steel wire drawing and rust preventives properties

HSDR is used to blend hobbing gear cutting, heavy to mild duty neat cutting oils, Heavy to mild duty stamping operations. HSDR is used to formulate chlorine free stainless steel wire drawing fluids. The products formulated on HSDR will give excellent rust preventive characteristics.

Typical Properties:

Appearance	:	Dark black to dark brown
		Free flowing liquid
Acid value	:	10 max Solubility
12.5 % Soln in Sn 500	:	Clear, no separation for 24 Hrs at 30°C

Products and Performance:

HOBBING GEAR CUTTING FLUIDS

HSDR	12.5 % W/W
SN 150 or SN 500	87.5 % W/W
Defoamer	50 ppm or as required

PERFORMANCE

Four ball EP load	800 kgs passing
Antiwear properties	
40 kgs, one hour	less than 0.03 mm scar dia

NEAT CUTTING OILS

HSDR	5 %
SN 150 or SN 500 or SN 70	95 %

Anti foam	As required
Four ball EP	400 kgs passing
HSDR	8 %
SN 150 or SN 500 or SN 70	92 %

Anti foam	As required
Four ball EP	600 kgs passing
HSDR	10 %
SN 150 or SN 500 or SN 70	90 %

Anti foam	As required
Four ball EP	750 kgs passing

STAMPING OPERATIONS:

Our HSDR neat cutting formulations can be used for mild stamping Operations, k.v at 40°C can be adjusted by using mixture of oils.

For Heavy duty operations like PN 204

HSDR	12.5 %
VI	2.5 %
SN 500 & BRIGHT STOCK	85 %

Combinations

K.V. at 40 deg c of finished will vary from 190 to 280 cst

Four Ball EP 800 Kgs passing

This formulation can be used as blanketing oils.

Note: VI SHOULD BE DISSOLVE IN OIL FIRST AND THEN HSDR SHOULD BE ADDED.

STAINLESS STEEL WIRE DRAWING FLUIDS

HSDR 12.5 %

SN 70, OR SN 150 & SN 500 85 %

Combinations

K.V. at 40 deg c of finished will vary from 25 to 70 Cst

Four ball EP 800 Kgs passing

RUST PREVENTIVE PROPERTIES

Our HSDR based formulations will protect the coated parts from rusting from one day to 15 days minimum depending upon HSDR additive percentage used.

For 5 % HSDR protection time is one day

For 10 % HSDR protection time is 10 day

For 12.5 % HSDR protection time is 15 day

Note: Do not Heat our HSDR directly.

50 % oil and additives is heated to 70°C and then remaining 50 % oil is added. This procedure has to be strictly followed.

THIS INFORMATION IS FOR GUIDELINES ONLY

On behalf of [Siddhi Trade Enterprise](#), we are pleased to have the opportunity to work with you and we look forward to establishing a solid, mutually beneficial business relationship.

Please feel free to contact us for further details. Assuring you our best services.

SIDDHI TRADE ENTERPRISE

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BRINGING EXCELLENCE TO THE PINNACLE